

Date: Tuesday, 7/17/2007 2:00:04 PM
 User: Kim Johnston

Process Sheet

| | | | |
|-----------------------|---|------------------|--------------------|
| Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : CLEVIS |
| Job Number | : 33585 | | |
| Estimate Number | : 10104 | | |
| P.O. Number | : <i>N/A</i> | Part Number | : D2012107 |
| This Issue | : 7/17/2007 | S.O. No. | : <i>N/A</i> |
| Prsht Rev. | : NC | Drawing Number | : D2012-107 REV. C |
| First Issue | : <i>N/A</i> | Project Number | : N/A |
| Previous Run | : 32551 | Drawing Revision | : C |
| | | Material | : <i>N/A</i> |
| Written By | : <i>[Signature]</i> | Due Date | : 8/12/2007 |
| Checked & Approved By | : <i>[Signature]</i> | Qty: | 100 Um: Each |
| Comment | : Est: D 01.11.08 Re-format, Drawing to Rev. C SM Est Rev:E Now on Waterjet 06-06-13 JLM | | |

Additional Product

Job Number:



| | | |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

| | | |
|-----|-----------|--------------------|
| 1.0 | M304S16GA | 304/316 .063 Sheet |
|-----|-----------|--------------------|



Comment: Qty.: 0.0146 sf(s)/Unit Total : 1.4595 sf(s)
 304/316 .063 Sheet
 (M304S063)
 Batch: *M103961*

SAD 07/07/20

| | | |
|-----|-----------|----------------|
| 2.0 | WATER JET | FLOW WATER JET |
|-----|-----------|----------------|



Comment: FLOW WATER JET
 1-Cut as per Dwg D2012-107
 Dwg Rev: *C*
 Prog Rev: *C*

2-Deburr if necessary

*SAD 07/07/20**(100)*

| | | |
|-----|-----|--|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*SAD 07/07/20**(100)*

| | | |
|-----|-----|--------------|
| 4.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



Comment: SECOND CHECK

*En 07/07/20**(100)*

| | | |
|-----|----------|----------|
| 5.0 | BRAKE NC | NO BRAKE |
|-----|----------|----------|



Comment: NC BRAKE

Form on press using DT8242 as per Dwg D2012-107

FF 07-08-09

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: R Date: 21/08/10
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Tuesday, 7/17/2007 2:00:04 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CLEVIS

Job Number: 33585

Part Number: D2012107

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



counted

Comment: INSPECT WORK TO CURRENT STEP

EC 07/08/09 (100)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

577

EC 7/8/9 (100)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



(100)

Comment: FINAL INSPECTION/W/O RELEASE

D 07/08/10

Job Completion



C 207/08/10

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

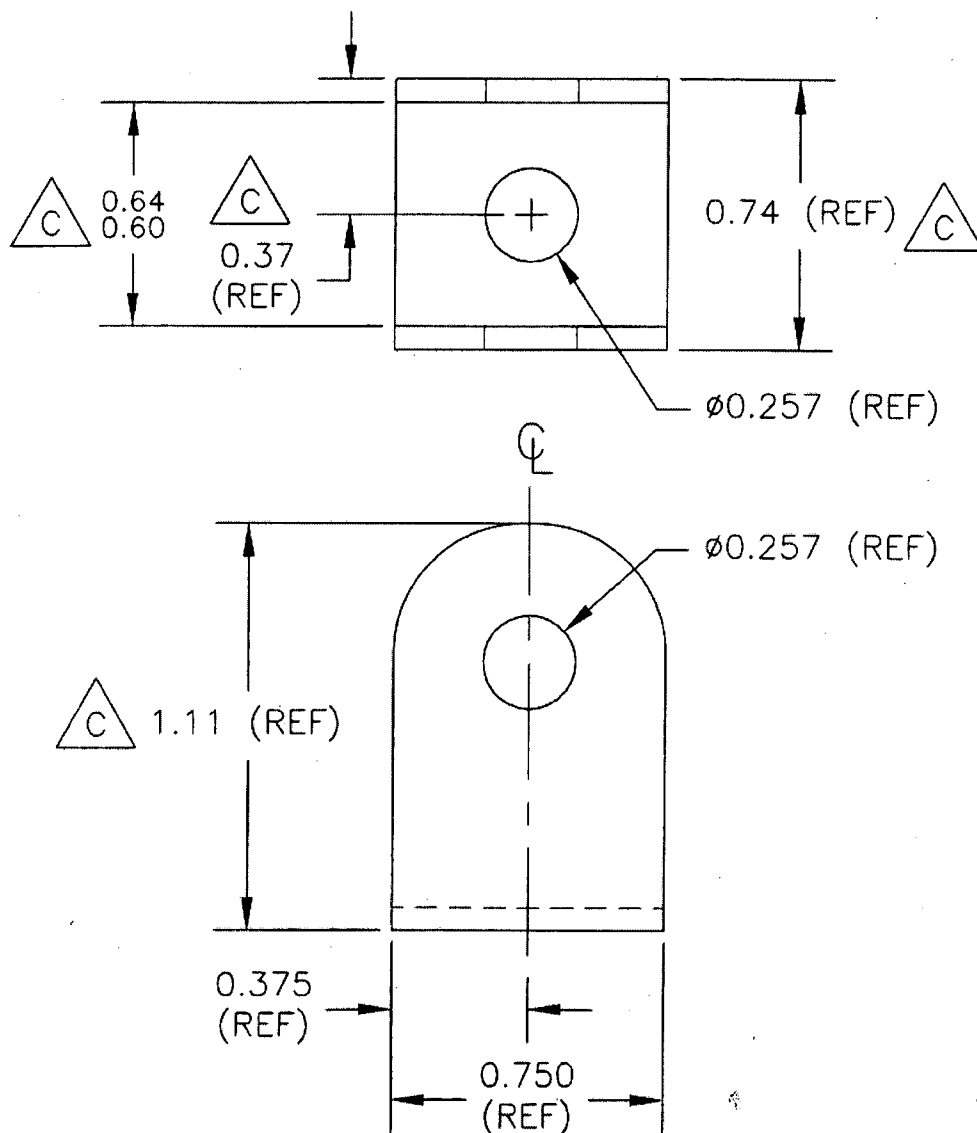
| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries



| | | | |
|-------------------------------|--------------------------------|---|------------------------|
| DESIGN BW | DRAWN BY RF | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D2012-107 | REV. C SHEET 1 OF 2 |
| DATE 99.12.20 | | TITLE CLEVIS | SCALE 2:1 |
| A | 94.10.27 | NEW ISSUE | |
| B | 99.04.30 | ADD FLAT PATTERN | |
| C | 99.12.20 | 0.74 WAS 0.680 | |

RELEASED
00.01.04 PS



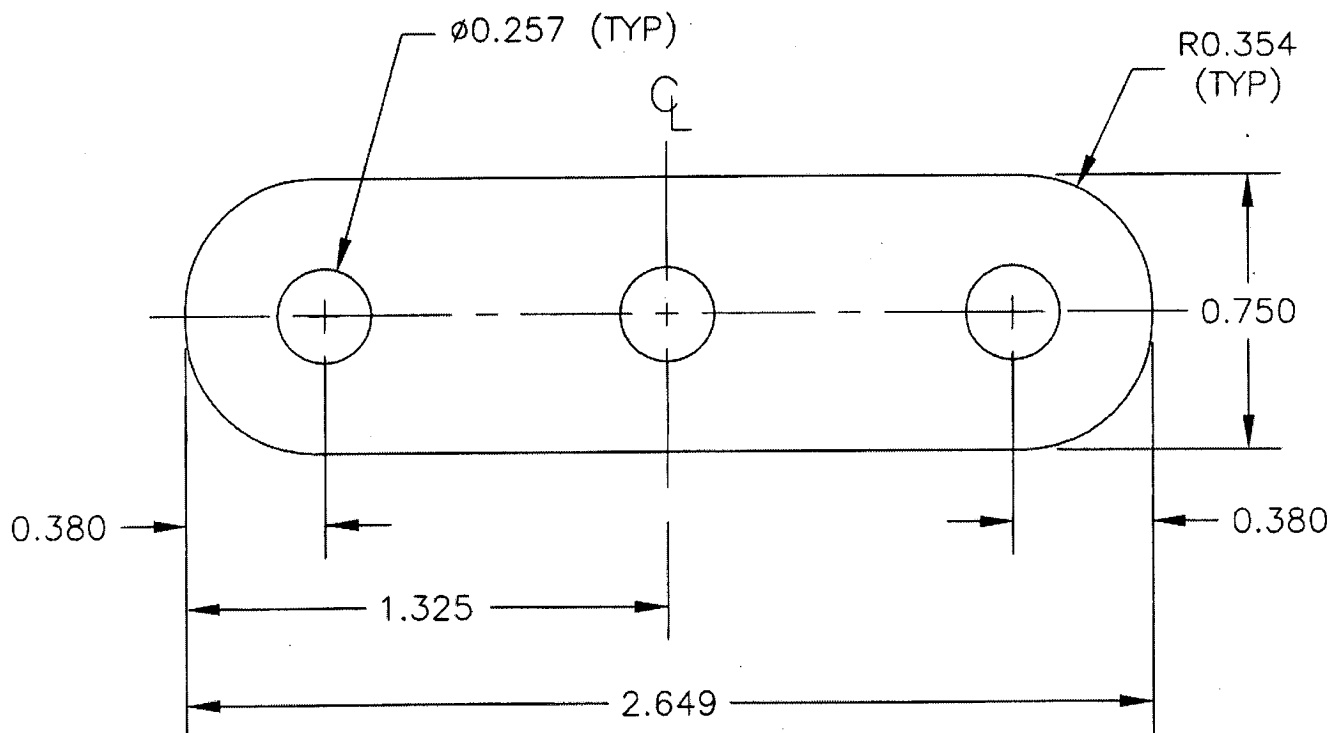
MATERIAL: AISI 304/316 SS 0.063 THICK
USE 0.032 BEND RADIUS
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 33585



| | | | |
|------------------------|-------------------------|---|------------------------|
| DESIGN BW | DRAWN BY RF | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED [Signature] | APPROVED [Signature] | DRAWING NO. D2012-107 | REV. C SHEET 2 OF 2 |
| DATE 99.12.20 | | TITLE CLEVIS | SCALE 2:1 |

RELEASED
00-01-04 PS



D2012-107 FLAT PATTERN

MATERIAL: AISI 304/316 SS 0.063 THICK
TOLERANCES ARE DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

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